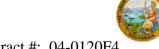
## **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: xx.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-019958 Address: 333 Burma Road **Date Inspected:** 25-Oct-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure

**OSM Departure Time: Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

**CWI Name: CWI Present:** Yes Mr. Huang Min No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** OBG BAY 5 to 8

## **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

#### BAY 6

Flux Cored Arc (FCAW) welding of welds joint CB3002J-001-285/286, And Welder is identified as 053742, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2134.

FCAW welding of welds joint CB3002K-004-287/288, And Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2134.

#### BAY 8

FCAW welding of welds joint BK004A8-053-002,007, And Welder is identified as 066401, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable

# WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2332-TC-P4-F.

FCAW welding of welds joint BK004A8-053-001,130, And Welder is identified as 066421, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2333-TC-P4-F.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07091

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as Bike Path welds. The weld designations reviewed are as follows.

- 1. BK004A2-053-009,010, 012,BK004A8-053-072, 073,076,078,080,082
- 2. BK004A6-053-072,073,086,088,090,092,096,098,100,102
- 3. BK004A4-053-006,007,021,032,033,058,059
- 4. BK004A3-053-043,044,059
- 5. BK004A3-045,046
- 6. BK004A4-053-004,005030,031,056,057
- 7. BK004A5-053-034,035,044,045,064,065,074,075
- 8. BK004A5R-053-113,114,119,120,126,127,129,130

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07099

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Bike Path weld. The weld designations reviewed are as follows.

- 1. BK4ASD1-053-018,021
- 2. BK004A5-053-112,115, 003,008,
- 3. BK004A3-053-007,009,010,002,003,005

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

## **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

## **Comments**

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer